

DART AEROSPACE LTD		Work Order:	22599
Description: Floor Window Kit, Small		Part Number:	D3212-1
Dwg: D3210 Rev. A; D3211 Rev. A; D3212 Rev. A; D3213 Rev. A; DSI 9266 Rev. A; D2125 Rev. A		Qty:	13 12 Kits
			Page 1 of 3

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D350-567-015 Floor Window Kit D2125 Floor Window Note: D350-567-015 Kit to be made in multiples of 4. Each Kit consists of (1) D3210-1, (1) D3211-1, (1) D3212-1, (1) D3213-1, (1) D3213-3, (1) D2125	HA	05.03.02	10
2	DC	Photocopy bluefile and create labels per PPP D350-567-015 CHG001 11.780" + DT8439 TEMPLATE			
3	MV	Cut blanks: 20.200" x 17.780" (+0.000/-0.010) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify as D3210-1 Batch:			
4	MV	Cut blanks: 17.800" x 11.375" (+0.000/-0.010) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Grain along 11.375" Identify as D3211-1 Batch:			
5	MV	Cut blanks: 15.250" x 9.200" (+0.000/-0.010) Material: 0.125" Polycarbonate (M-LEXAN-S.125) Identify as D3212-1 Batch: M 16845	EP	05/03/30	20
6	MV	Cut blanks: 15.100" x 4.500" (+0.000/-0.010) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify as D3213-1 Batch:			
7	MV	Cut blanks: 15.100" x 4.500" (+0.000/-0.010) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify as D3213-3 Batch:			
8	MV	Machine D3210-1 as per Folio FA347 and Dwg D3210 Stack of 4			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr to take measurement			
11	QC8	Second check			
12	MV	Machine D3211-1 as per Folio FA348 and Dwg D3211 Stack of 4			
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr to take measurement			
15	QC8	Second check			
16	MV	Machine D3212-1 as per Folio FA349 and Dwg D3212 Stack of 4	EP	05/03/30	20
17	QC2	Inspect parts as they come off the CNC machine	EP	05/03/30	20
18	MV	Deburr to take measurement	EP	05/03/30	20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22599
Description: Floor Window Kit, Small		Part Number:	D350-567-015 D3212-1
Dwg: D3210 Rev. A; D3211 Rev. A; D3212 Rev. A; D3213 Rev. A; DSI 9266 Rev. A; D2125 Rev. A		Qty:	10 Kits
			Page 2 of 3

Step	Location	Procedure	By	Date	Qty																				
19	QC8	Second check	gml	05/03/30	20																				
20	MV	Machine D3213-1 as per Folio FA350 and Dwg D3213 Stack of 4																							
21	QC2	Inspect parts as they come off the CNC machine																							
22	MV	Deburr to take measurement																							
23	QC8	Second check																							
24	MV	Machine D3213-3 as per Folio FA350 and Dwg D3213 Stack of 4																							
25	QC2	Inspect parts as they come off the CNC machine																							
26	MV	Deburr to take measurement																							
27	QC8	Second check																							
28	QC5	Inspect work to Step 27																							
29	GB	Deburr D3210-1, D3211-1, D3212-1, D3213-1, D3213-3 Stack	SB	05/04/06	00																				
30	GB	Bend D3211-1 Stack as per Dwg D3211																							
31	QC5	Inspect work to Step 30																							
32	FP	Chemical Conversion Coat D3210-1, D3211-1, D3213-1, D3213-3 as per QSI 005 4.1																							
33	GA	Pick: Assembly Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3161-3</td><td>Hinge</td><td></td></tr><tr><td>1</td><td>D3213-1</td><td>Door</td><td></td></tr><tr><td>1</td><td>D3213-3</td><td>Door</td><td></td></tr><tr><td>24</td><td>MS20470AD4-4</td><td>Rivet</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D3161-3	Hinge		1	D3213-1	Door		1	D3213-3	Door		24	MS20470AD4-4	Rivet				
Qty	Part Number	Description	Batch																						
2	D3161-3	Hinge																							
1	D3213-1	Door																							
1	D3213-3	Door																							
24	MS20470AD4-4	Rivet																							
34	GA	Assemble as per Dwg D3213 Identify as D3213-041																							
35	QC5	Inspect work to Step 34 29	AB	05/04/06	131																				
36	FP	Powder Coat Black Sandtex (Ref 4.3.5.7) per QSI 005 4.3 D3210-1, D3211-1 & D3213-041																							
37	QC3	Inspect Powder Coat																							

RELEASED

03.09.14

Dart Aerospace Ltd

W/O: _____

Dart Aerospace Ltd

WORK ORDER CHANGES							
W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
DATE	STEP						

WORK ORDER NON-CONFORMANCE (NCR)								
NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
DATE	STEP		Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	22599
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.731	✓			
6.367	+/-0.005	6.365	✓			
0.625	+/-0.005	0.627	✓			
0.156	+0.005/-0.000	0.156	✓			
R0.25	+/-0.030	0.25	✓			
8.150	+/-0.005	8.151	✓			
3.750	+/-0.005	3.752	✓			
0.313	+/-0.010	0.314	✓			
15.14	+/-0.030	15.146	✓			
12.520	+/-0.005	12.525	✓			
6.260	+/-0.005	6.265	✓			
1.312	+/-0.005	1.313	✓			
0.313	+/-0.010	0.314	✓			
3.750	+/-0.005	3.753	✓			
8.150	+/-0.005	8.154	✓			
8.462	+/-0.005	8.465	✓			
9.09	+/-0.030	9.090	✓			

Measured by: <i>ER</i>	Audited by: <i>gm</i>	Prototype Approval:	N/A
Date: 05/03/30	Date: 05/03/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	<i>[Signature]</i>

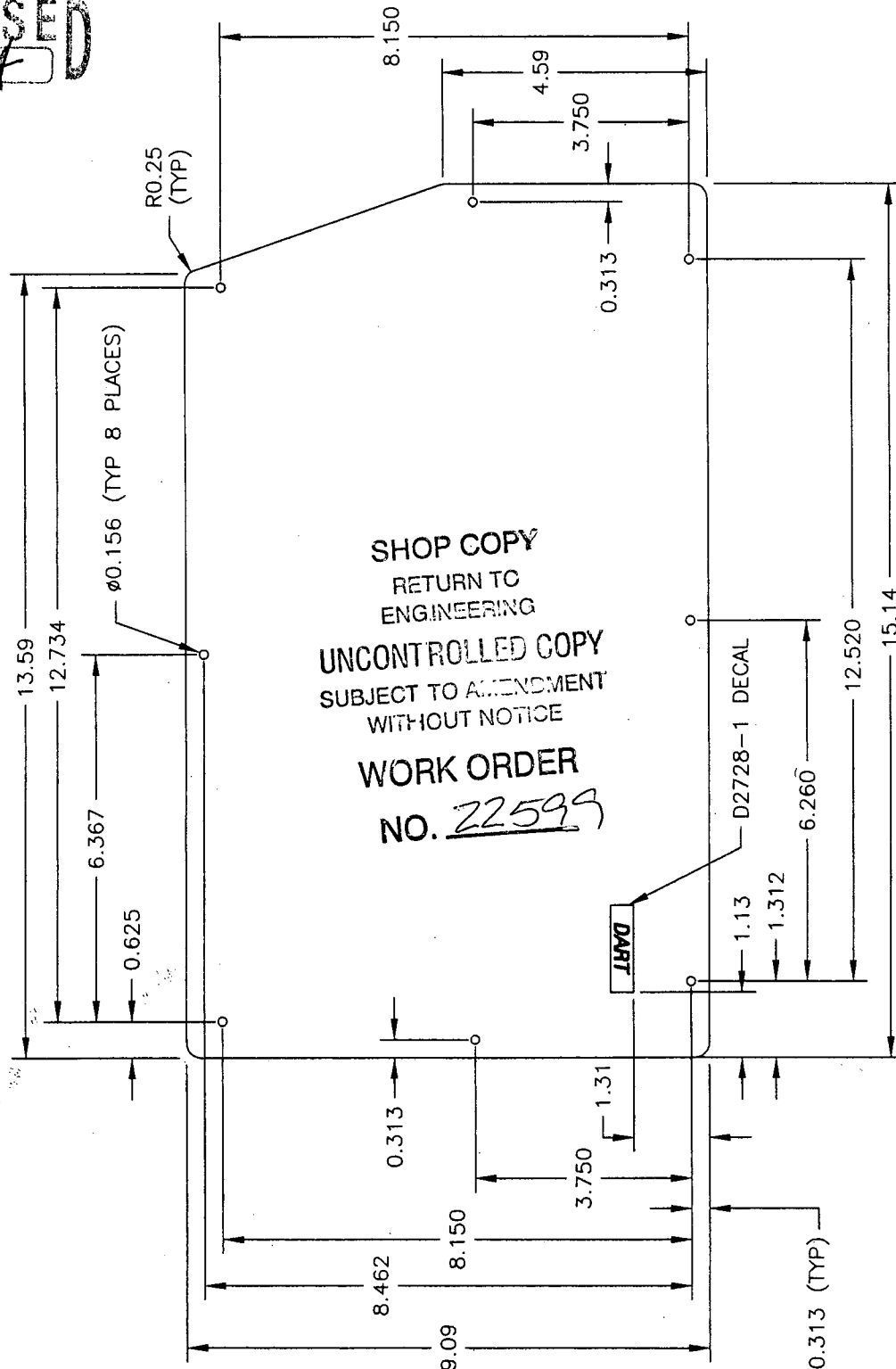
RELEASED

RF 04.01.14



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3212	REV. A SHEET 1 OF 1
DATE 03.09.03		TITLE FLOOR WINDOW	SCALE 1:3
A	03.09.03	NEW ISSUE	

RELEASED
03.09.03



D3212-1 FLOOR WINDOW
MACHINE PER DRAWING FILE "D3212-A1.DWG"
CHECK WITH TEMPLATE D3212-1T1
DIMENSIONS ARE FOR REFERENCE ONLY
MATERIAL: 1/8 CLEAR POLYCARBONATE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 01, 2005
11:19 am

Work Order No : 0022599
Project Name : D3212-1
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D3212-1
Description : Floor Window
Manufactured : No
Amount Req'd : 8 10
Amount Done : 0
Start Date : 03-01-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00